







Date: Thursday, 8/30/2007 3:49:50 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 34352	
Estimate Number : 12785	
P.O. Number : N/A	Part Number : D356411
This Issue : 8/30/2007 S.O. No. : N/A	Drawing Number : D3564 REVC
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 33799	Material : N/A
Written By : <u>8/30/07.08.31</u>	Due Date : 9/18/2007
Checked & Approved By : <u>8/30/07.08.31</u>	Qty: <u>40</u> Um: Each
Comment : Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304S16GA 304/316 .063 Sheet
	
Comment: Qty.: 0.9177 sf(s)/Unit Total : 18.3540 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>M10530</u> <u>18 07-09-01</u>	
2.0	WATER JET FLOW WATER JET
	
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: <u>C</u> Prog Rev: <u>C</u> <u>18 07-09-01</u>	
2-Deburr if necessary <u>18 07-09-12</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>18 07-09-01</u>	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <u>8/21/09/12</u> <u>440</u> <u>contg</u>	
5.0	BRAKE NC NC BRAKE
	
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT <u>8179</u> and DT <u>8157</u>	
<u>815 07/09/19</u> <u>40</u>	

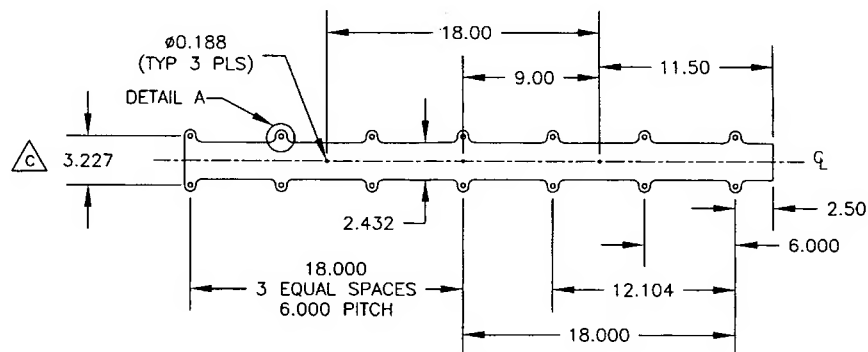
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

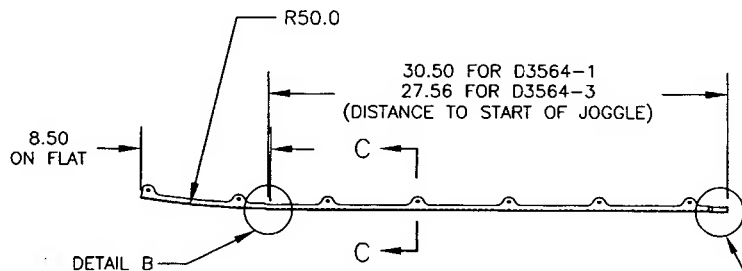
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

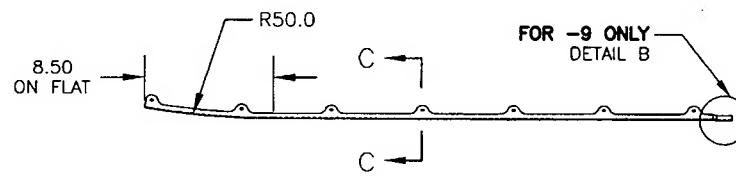
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

FOR -1 ONLY
DETAIL B

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

UNDER REVIEW
07.03.17 CB
add by wearplate
CB 07.08.30
RELEASED
07.06.28

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

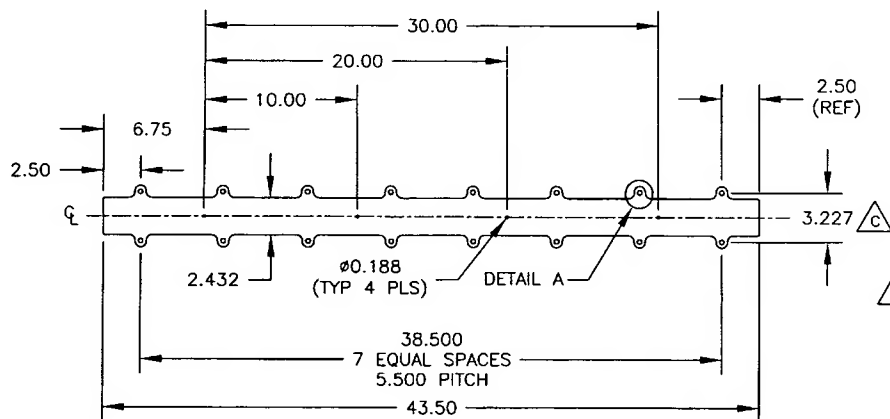
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

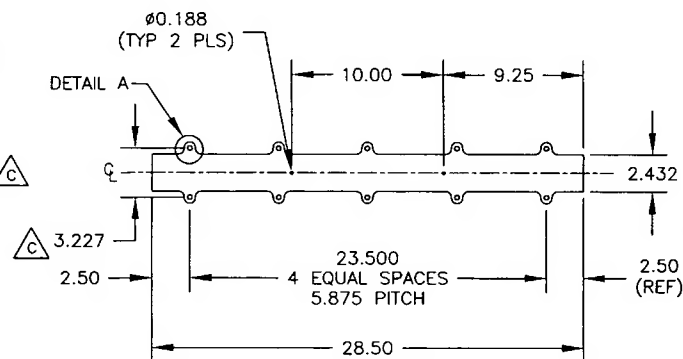
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. WARRIMUR, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3564
DATE	07.04.17	TITLE WEARSHOE
		REV. C SHEET 1 OF 2 SCALE 1:8

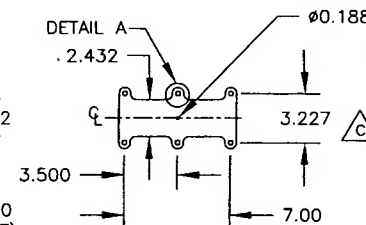
NO. 34352
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



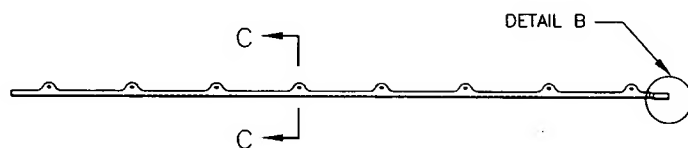
D3564-5F FLAT PATTERN



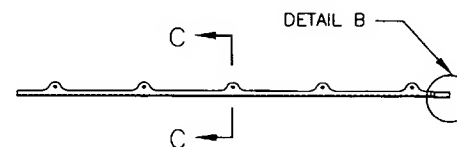
D3564-7F FLAT PATTERN



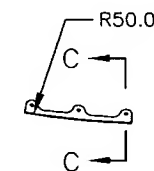
D3564-13F FLAT PATTERN



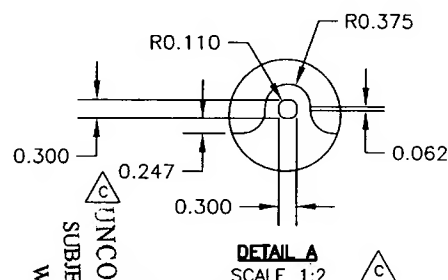
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



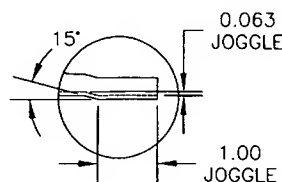
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



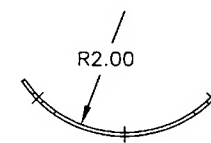
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

07.08.30
CB

UNDER REVIEW

07.08.21 CB
adding wearplate

RELEASED
07.08.28

NO. 34352
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. WARRIMUR, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3564	REV. C SHEET 2 OF 2
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:8

DART AEROSPACE LTD		Work Order:	345
Description: WEAR PAD		Part Number:	P3504-11
Inspection Dwg:	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[illegible]